

Date: Thursday, 3/2/2006 3:07:12 PM
User: Kim Johnston

Process Sheet

13

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR 212/412
Job Number	: 26024		
Estimate Number	: 10887		
P.O. Number	: N/A	Part Number	: D412711011
This Issue	: 3/2/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: N/A
Previous Run	: 26023	Material	: N/A
Written By	: <u>SRR COMMENT BELOW</u>	Due Date	: 3/30/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>06.03.02</u>		
Comment	: Est Rev:A 04.09.29 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

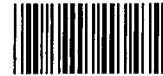
DH : 06/03/06

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Issued 706

u



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

06.03.03

3.0	D412711041	Vertical Ref. Door Assy
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-041 Vertical Reference Door

25609

4.0	D412711111	Wiring Harness, 212/412
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Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

B21801 ✓

5.0	EA2046915412	Instrument Panel, 412
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

M19150 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 06/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 26024

Part Number: D412711011

Job Number:



06/03/13

Seq. #:

Machine Or Operation:

Description :

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/03/13

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-711-011

Location: _____

PPP Rev: _____

06/03/13

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/13

Job Completion



06/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
Job Number : 25669	
Estimate Number : 10902	
P.O. Number : N/A	Part Number : D412711041
This Issue : 1/30/2006 S.O. No. : N/A	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 21476	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 2/20/2006 Qty: 1 Um: Each
Checked & Approved By : <u>KJ 06.01.30</u>	
Comment : Est Rev:A 04.08.18 New Issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 494 to Eagle Copters

u 06-02-01

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door _____

Attach serviceable tags

See attached

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window _____

1 EA20469-05 Rubber Strip _____

1 EA20469-06 Aluminum Strip _____

1 EA20469-07 Angle _____

1 EA20469-08 Placard _____

1 EA20469-10 Rear Rib Assy _____

1 EA20469-11 Angle _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25669

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	EA20469-12	Fwd Rib _____
1	EA20469-13	Window _____
1	EA20469-14	Window Retainer _____
1	EA20469-16	Armrest Assy _____
1	EA20469-17	Angle _____
1	EA20469-18	Door Inner Skin _____
1	EA20469-21	Door Cover Panel _____
2	EA20469-23	Link _____
1	EA20469-24	Rod _____
1	EA20469-25	Arm Assy _____

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
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14	AN3-3ABolt	_____	_____
22	AN3-4ABolt	_____	_____
24	AN3-7ABolt	_____	_____
6	AN960-6L Washer	_____	_____
90	AN960-10L Washer	_____	_____
34	CR3242-4-2 Rivet	_____	_____
135	MS20426AD3-3 Rivet	_____	_____
140	MS20426AD4-3 Rivet	_____	_____
25	MS20470AD3-3 Rivet	_____	_____
90	MS20470AD4-3 Rivet	_____	_____
24	MS21042L3 Nut	_____	_____
2	MS21042L06 Nut	_____	_____
13	MS21069L3 Nut Plate	_____	_____
8	MS21069L08 Nut Plate	_____	_____
1	MS21071L3 Nut Plate	_____	_____
1	MS21071L08 Nut Plate	_____	_____
9	MS21075L3 Nut Plate	_____	_____
2	MS24677-12 Screw	_____	_____
6	MS27039-1-09 Screw	_____	_____

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25669

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RB Date: 06/03/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd.Date: Friday, 2/20/2006 2:30:21 PM
User: Linda Lacelle**Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	: 25869	Part Number	: D412711041
Estimate Number	: 10902	Drawing Number	: N/A
P.O. Number	:	Project Number	: N/A
This Issue	: 2/2/2006 S.O. No. :	Drawing Revision	: N/A
Print Rev.	: NC	Material	: N/A
First Issue	: 1/30/2006 Type : PURCHASED PARTS	Due Date	: 2/20/2006 Qty: 1 Unit: Each
Previous Run	: 21476		
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev: A D4.08.18 New Issue KJ/JS		

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: _____ to Eagle Copters

Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES

Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick/Qty	Part Number	Description	Batch
1	204-030-853-119	LH Co-pilot Door	4640359

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L / EA20469-3	Window	30473

1 EA20469-05 Rubber Strip

1 EA20469-06 Aluminum Strip

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

N/A

4640359

Date: Friday, 2/3/2006 2:30:01 PM
User: Linda Loeble

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25660

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

- | | | | |
|---|------------|------------------|-------|
| 1 | EA20469-12 | Fixed Rib | _____ |
| 1 | EA20469-13 | Window | _____ |
| 1 | EA20469-14 | Window Retainer | _____ |
| 1 | EA20469-16 | Armrest Assy | _____ |
| 1 | EA20469-17 | Angle | _____ |
| 1 | EA20469-18 | Door Inner Skin | _____ |
| 1 | EA20469-21 | Door Cover Panel | _____ |
| 2 | EA20469-23 | Link | _____ |
| 1 | EA20469-24 | Rod | _____ |
| 1 | EA20469-25 | Arm Assy | _____ |

W/640359

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

- | | | |
|-----|----------------------|----------------|
| 14 | AN3-3ABdt | 01196 |
| 22 | AN3-4ABdt | 59578 |
| 24 | AN3-7ABdt | 17597 |
| 6 | AN960-6L Washer | 13051 |
| 90 | AN960-10L Washer | 57511 |
| 34 | CR3242-4-2 Rivet | 59327 / 625216 |
| 135 | MS20428AD3-3 Rivet | 50331 |
| 140 | MS20428AD4-3 Rivet | 50331 |
| 25 | MS20470AD3-3 Rivet | 52175 |
| 90 | MS20470AD4-3 Rivet | 52175 |
| 24 | MS21042L3 Nut | 54485 |
| 2 | MS21042L08 Nut | 55447 |
| 13 | MS21069L3 Nut Plate | 024569 |
| 8 | MS21069L08 Nut Plate | 019155 |
| 1 | MS21071L3 Nut Plate | 024567 |
| 1 | MS21071L08 Nut Plate | 55874 |
| 9 | MS21075L3 Nut Plate | 04764 |
| 2 | MS24877-12 Screw | 11931 |
| 6 | MS27039-1-09 Screw | 16766 |

4-Assemble door in accordance with: D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 6 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker Ref PO- 001636.7

02/02/2006 16:03 6136321053 DART: AEROSPACE PAGE 004

Date: Friday, 2/3/2006 2:30:01 PM
User: Linda Lacolla

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25669

Part Number: DA12711041

Job Number:

Seq. #: Machine Or Operation:

Description:

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS
Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion